303.750

Work Order ID 68247

Monday, April 11, 2011 10:19:01 AM

Item ID: D3873-1 **Accept**

Revision ID:

Item Name: Bushing

Setup **Start** / **Stop**

Start Date: 4/11/2011 **Start Qty:** 100.00 **Cust Item ID:**

Required Date: 4/14/2011 **Req'd Qty:** 100.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 11-04-11 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** / **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3873	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Hardinge Hardinge CNC Lathe Small	**Memo** 1-TURN AS PER FOLIO FA806 & DWG D3873 , FOLIO REV: U/A DWG REV: B 2-DEBURR AS REQUIRED SA 11/5/26	0.00 0.00				100	Ø		
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				100	Ø		

SA 11/5/26

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68247

Monday, April 11, 2011 10:19:01 AM

Item ID: D3873-1 **Accept** **Setup** **Start**

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Run **Start** **Stop**

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	B.A 11/05/26			100	ϕ		
130 Packaging Packaging	Identify as per dwg & Stock Location: 84 **Memo**	0.00 0.00				11/5/27			100
140 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00						11/5/30	

MF 11-05-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, April 11, 2011 10:19:07 AM

Work Order ID: 68247

Parent Item: D3873-1

Parent Item Name: Bushing

Start Date: 4/11/2011 **Required Date:** 4/14/2011

Start Qty: 100.00 **Required Qty:** 100.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 303 Round Bar 0.750		Purchased	No			100	f	125.2100	0.06	6		11/5/12 6	

Location	Loc Qty	Loc Code
MAT028	125.21	
117142	65.21	
117328	60	

6 ft

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	68247
Description: Bushing	**Part Number:**	**D3873-1**
Inspection Dwg: D3873 **Rev:** B		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.305	+0.000/-0.002	Ø.304	✓		SA-5	
Ø0.191	+0.005/-0.001	Ø.192	✓			
Ø0.563	+/-0.010	Ø.564	✓			
0.060	+/-0.005	.060	✓		SA-9	
0.600	+/-0.010	.600	✓			
R0.010	+/-0.010	R.015	✓			
0.030 x 20°	+/-0.010 x 0.5°	.030x20°	✓			

Measured by:	[signature]	Audited by:	G.A	Preliminary Approval:	
Date:	11/5/26	Date:	11/05/26	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.11.05	Dimensions updated per Dwg Rev B	KJ [initials]	[initials]

Dart Aerospace Ltd

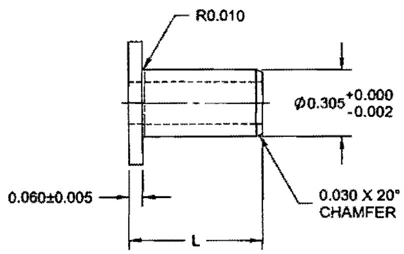
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

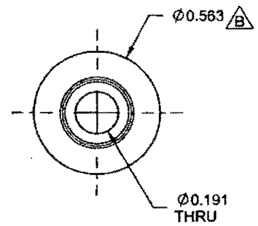
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

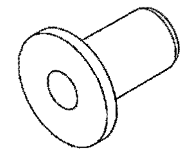
Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6847

R11-04-D

D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.01

RELEASED
2010-09-15

REV.	DESCRIPTION	BY	DATE
B	Ø0.563 WAS Ø0.63 (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07

DESIGN	CP
DRAWN	CP
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.07.22

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3873 — REV. B — SHEET 1 OF 1

TITLE: BUSHING — SCALE: NTS

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: PER TABLE

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ________ **Fault Category:** ____________ **NCR:** Yes No **DQA:** ______ **Date:** __________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** __________ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries